

Work Order ID 69889

Tuesday, May 24, 2011 10:04:14 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 5/24/2011 Start Qty: 40.00

Required Date: 5/31/2011 Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



BAND SAW

FK- 11/07/25 80 8

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

Issue PO 14572

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Photo FA405 and Dwg D3278-1-2- Deburr and Tumble Identify as D3278-1

DM's Precision Machine per drawing D3278 Rev C

11.08.04

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Receive + inspect for transit damage Ensure C of C attached

11/17/11 (70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69889

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Page 2

Item ID:	D3278-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Support					
Start Date:	5/24/2011	Start Qty:	40.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC Inspect parts - second check Memo	0.00 0.00				count (x70) as per			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

70x ~~Ø~~ m-f 11/04/08

70x ~~Ø~~ m-f 11/04/08

M 117745

1:00
START TIME: 3200F
FINISH TIME: 1:30
OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 69889

Tuesday, May 24, 2011 10:04:14 AM



Page 3

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 5/24/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11 09 08 70

170



Packaging

Packaging

Identify as per dwg & Stock Location: 6A

0.00

Memo

0.00

11/09/09 70

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/12 70
mf
11-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 10:04:21 AM

Page 1

Work Order ID: 69889

Parent Item: D3278-1

Parent Item Name: Support



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	32.7500	0.2337	9.84			



6061-T6 Bar 1.00 x 2.00



KK 11/07/25

Location	Loc Qty	Loc Code
MAT004	32.75	
112567	22.6	
114415	0.87	
115045	5.6	
116623	3.36	
117379	0.32	
118106		

0.87
5.6
0.32
2.871

W/O:		WORK ORDER CHANGES					
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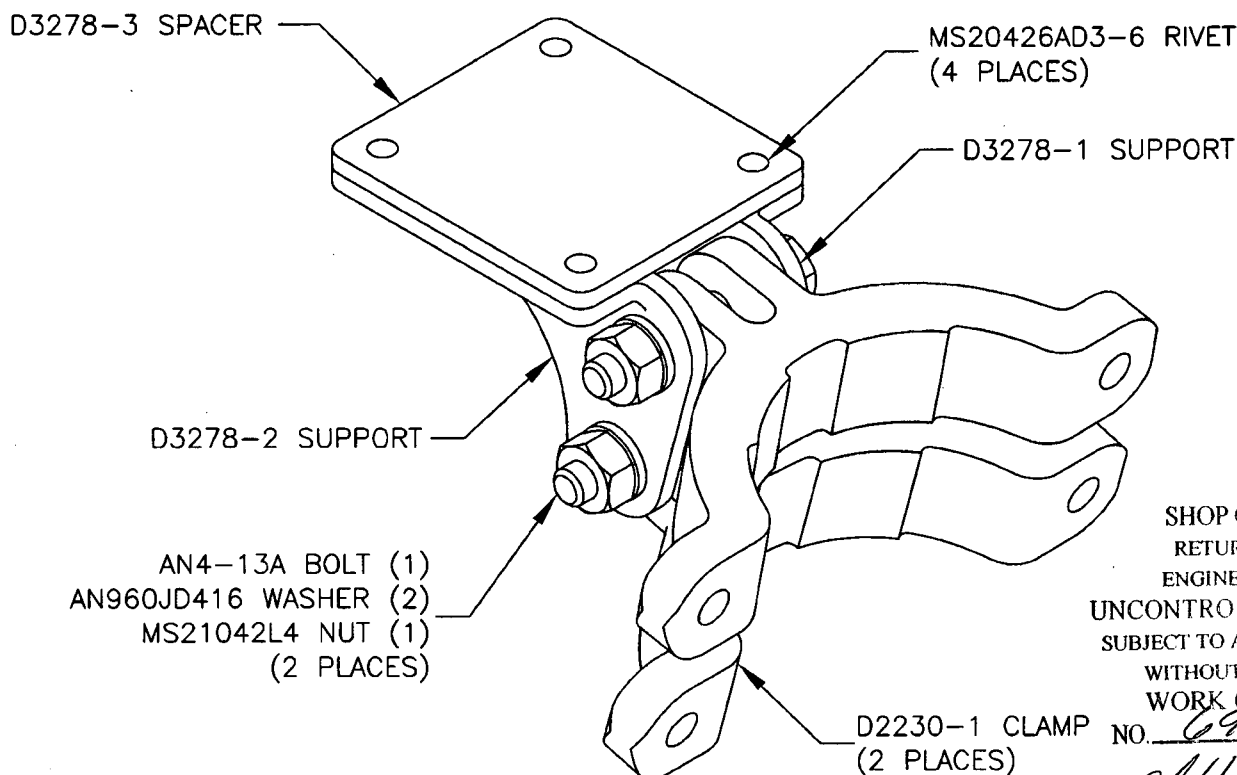
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-05

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69889*

P/11-05-24

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

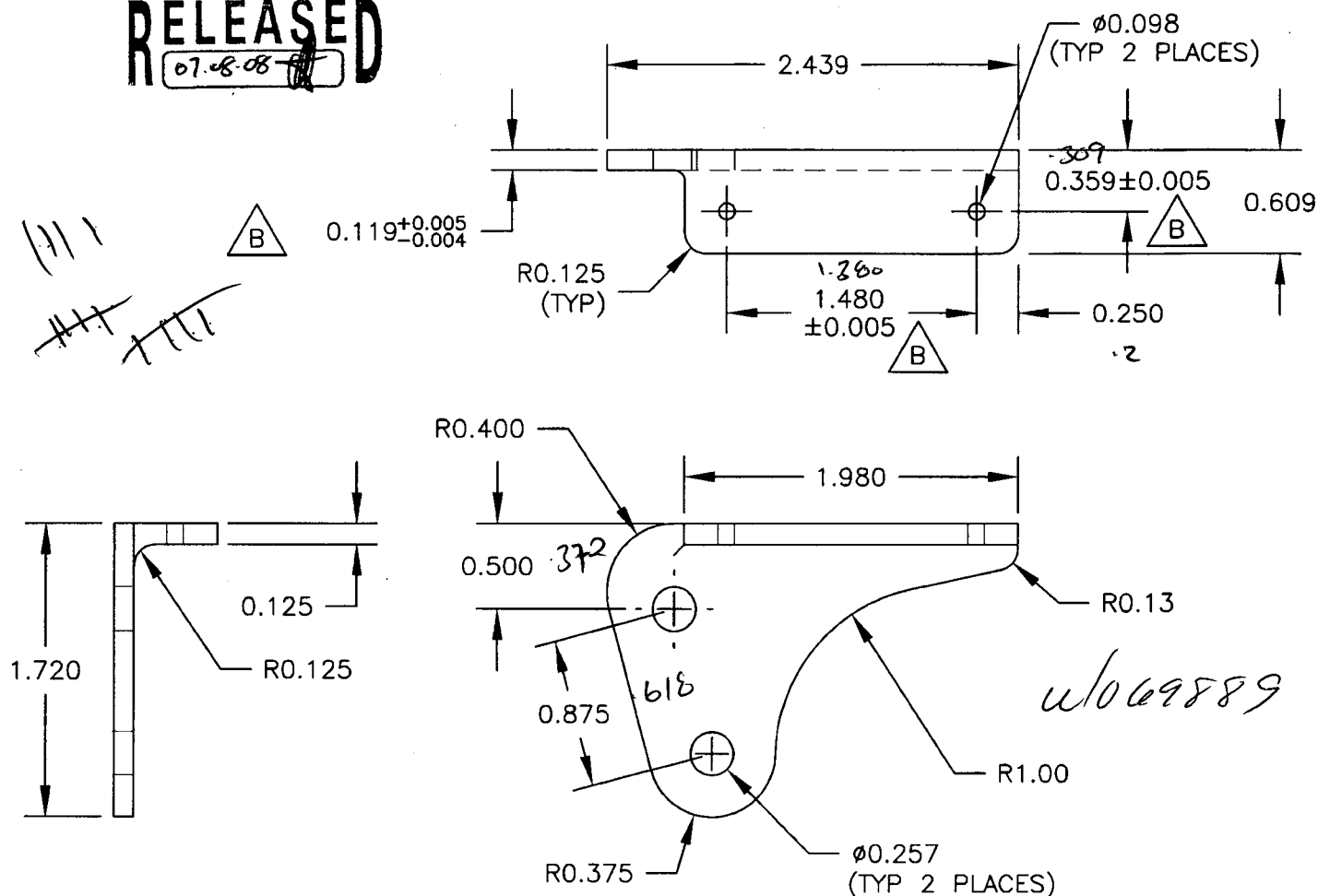
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DESIGN <i>90</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR1"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

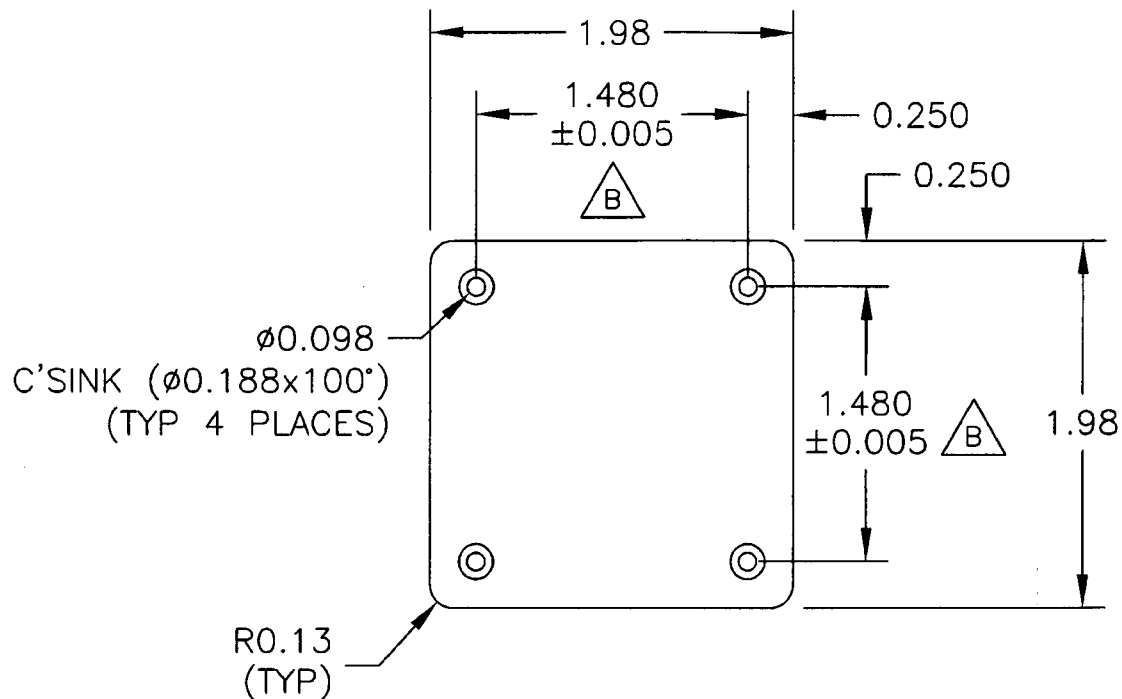
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NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 06-Sep-11
Purchase Order : PO14572
Packing Slip : 10713
Part Number : D3278-1revC
Quantity : 70

Per: _____

For Dan's Precision Tools Inc.